

Date: Wednesday, 17/12/2008 1:52:48 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOWER DOUBLER
Job Number : 44149	
Estimate Number : 12808	
P.O. Number :	Part Number : D36081
This Issue : 17/12/2008 S.O. No. :	Drawing Number : D3608 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 42609	Material :
Written By :	Due Date : 09/01/2009 Qty: 5 Um: Each
Checked & Approved By : <u>JW 08.12.17</u>	
Comment : Est Rev:A New Issue 07-03-26 JLM Est Rev:B 08-10-15 preliminary issue DD verified by:EC Est Rev:C 08-12-11 rev.A as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.7762 sf(s)/Unit Total: 3.1046 sf(s)
 304/316 .040 Sheet
 Batch: 42609 109088 HB 9-1-7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3608
 Dwg Rev: A
 Prog Rev: A

HB 9-1-7

2-Deburr if necessary HB 9-1-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Deburr if necessary
 2- Bend as per Dwg D3608

SB 09/01/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LOWER DOUBLER

Job Number: 44149

Part Number: D36081

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/12 GR

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PP44146

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/14 JH

Job Completion



MF 09-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44149
Description: LOWER DOUBLET		Part Number: D3608-1
Inspection Dwg: D3608-1, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	✗			
.500	+/- .010	.500	✓			
1.827	+/- .010	1.822	✗			
8.100	+/- .010	8.099	✗			
11.63	+/- .030	11.625	✓			
.500	+/- .010	.504	✗			
2.25	+/- .030	2.247	✗			
2.26	+/- .030	2.262	✗			
1.813	+/- .010	1.816	✗			
3.750	+/- .010	3.753	✗			
1.25	+/- .030	1.248	✗			
.400	+/- .010	.4003	✗			
1.350	+/- .010	1.353	✗			
8.90	+/- .030	8.897	✗			
.345	+/- .010	.344	✗			
1.875	+/- .010	1.874	✗			
.423	+/- .010	.423	✗			
6.916	+/- .010	6.913	✗			
2.90	+/- .030	2.90	✓			
2.179	+/- .010	2.177	✗			
8.44	+/- .030	8.424	✗			
1.344	+/- .010	1.344	✗			
6.854	+/- .010	6.854	✗			

Measured by: RB
Date: 8-1-07

Audited by: S
Date: 09/01/07

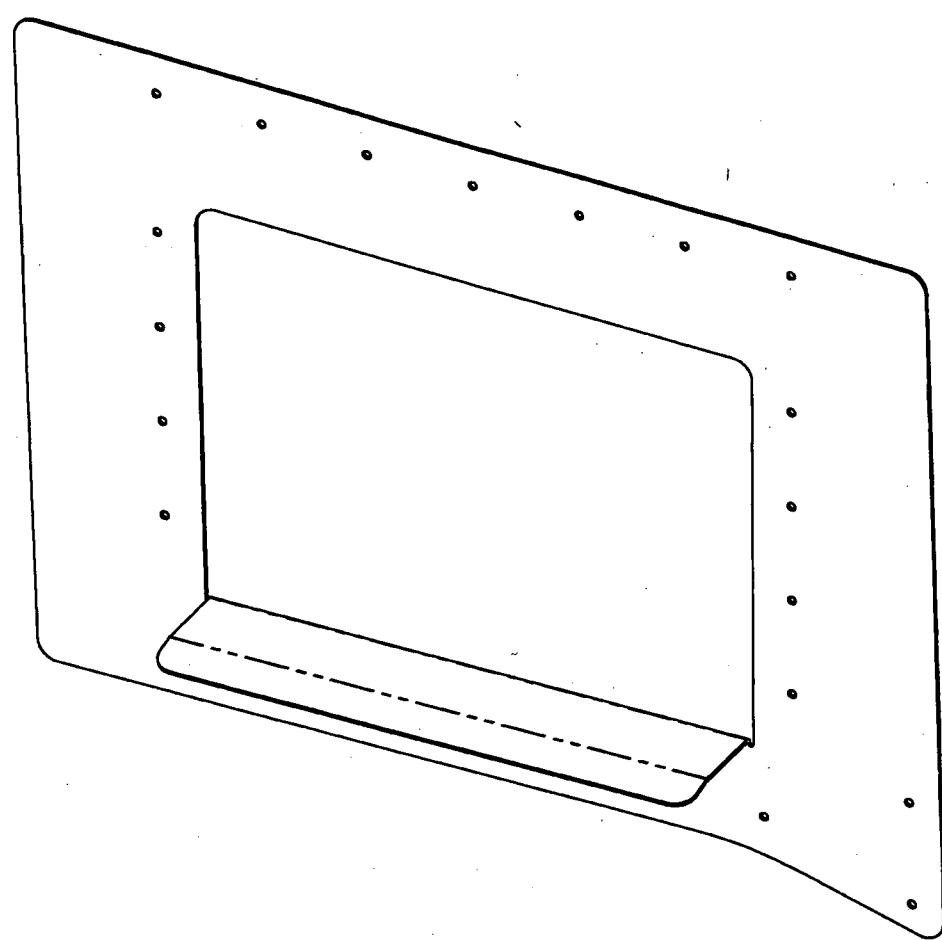
Prototype Approval: 1
Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

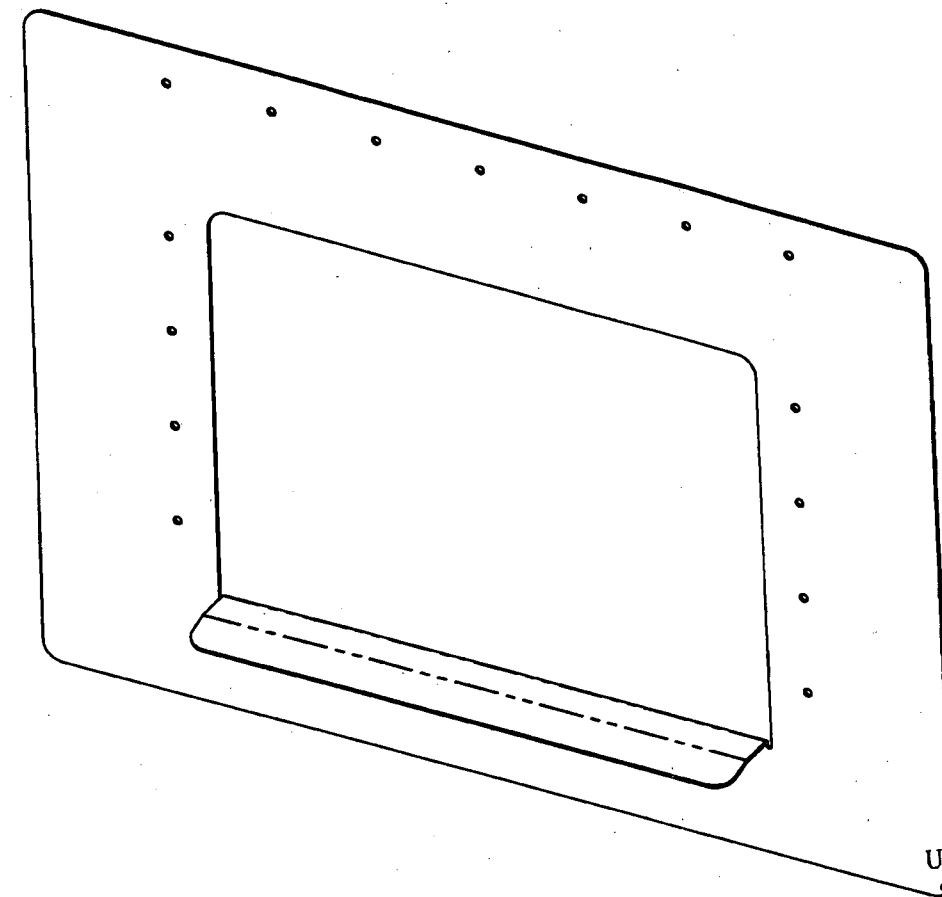
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3608-1 LOWER DOUBLER



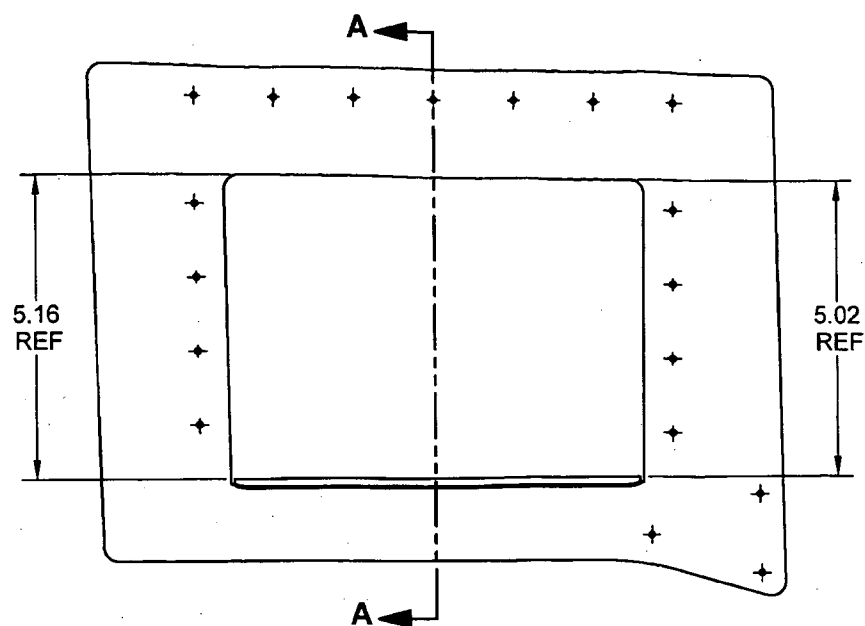
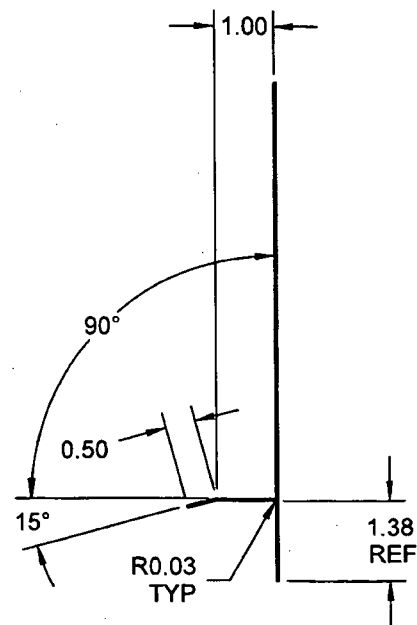
D3608-3 UPPER DOUBLER

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WORK ORDER
NO. 4414

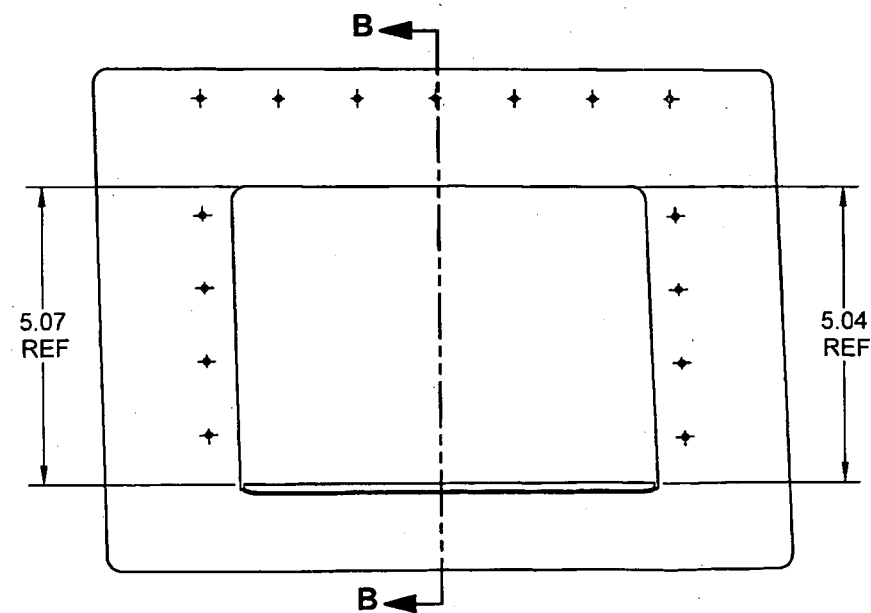
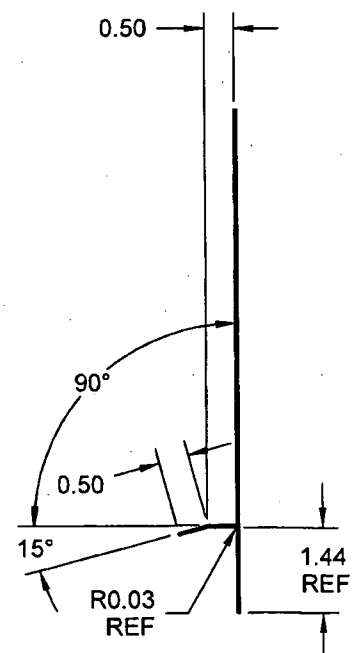
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08/12/10

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.76 lbs EACH

A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 4	
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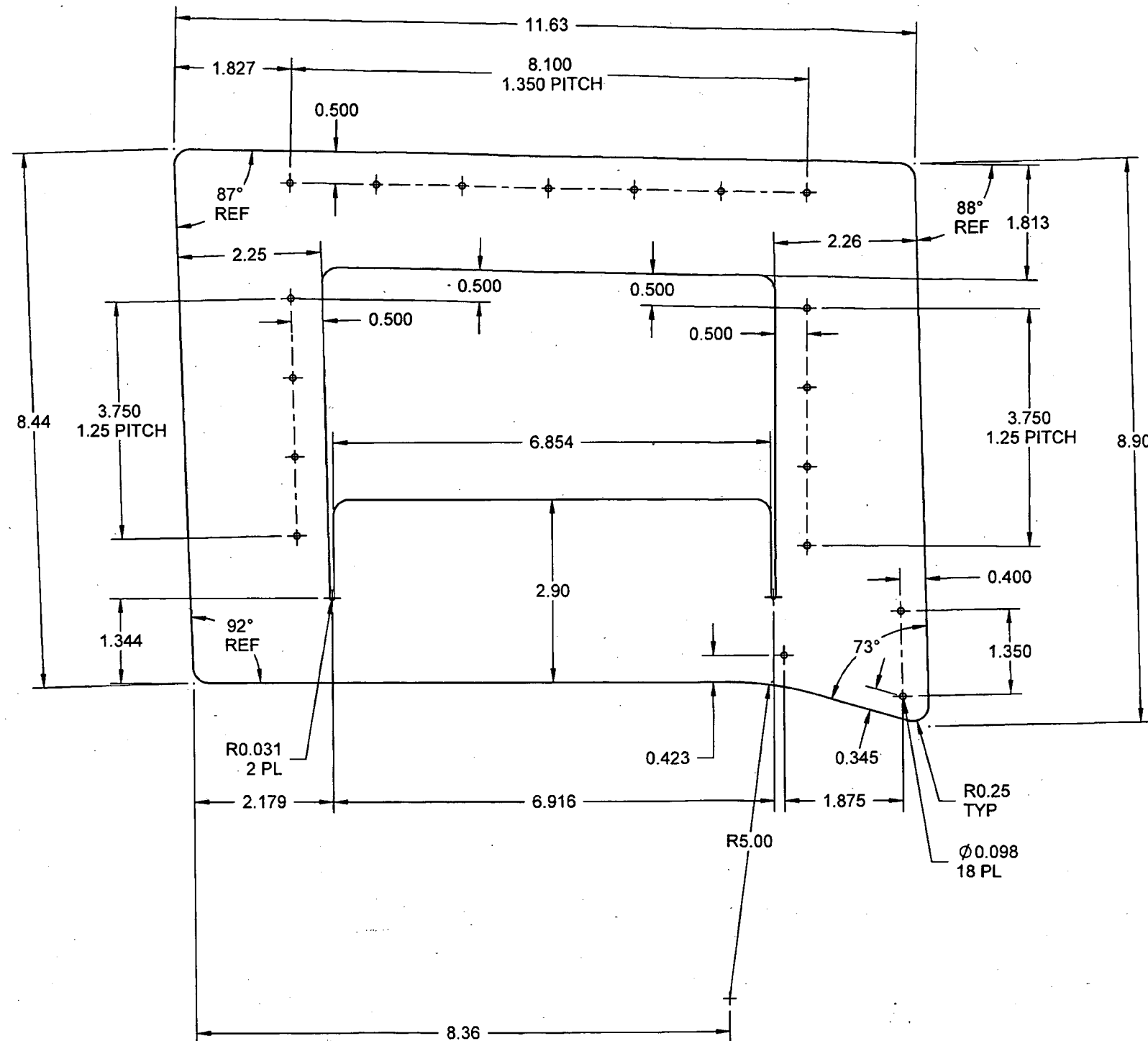


D3608-3 UPPER DOUBLER
(MAKE FROM D3608-3F)

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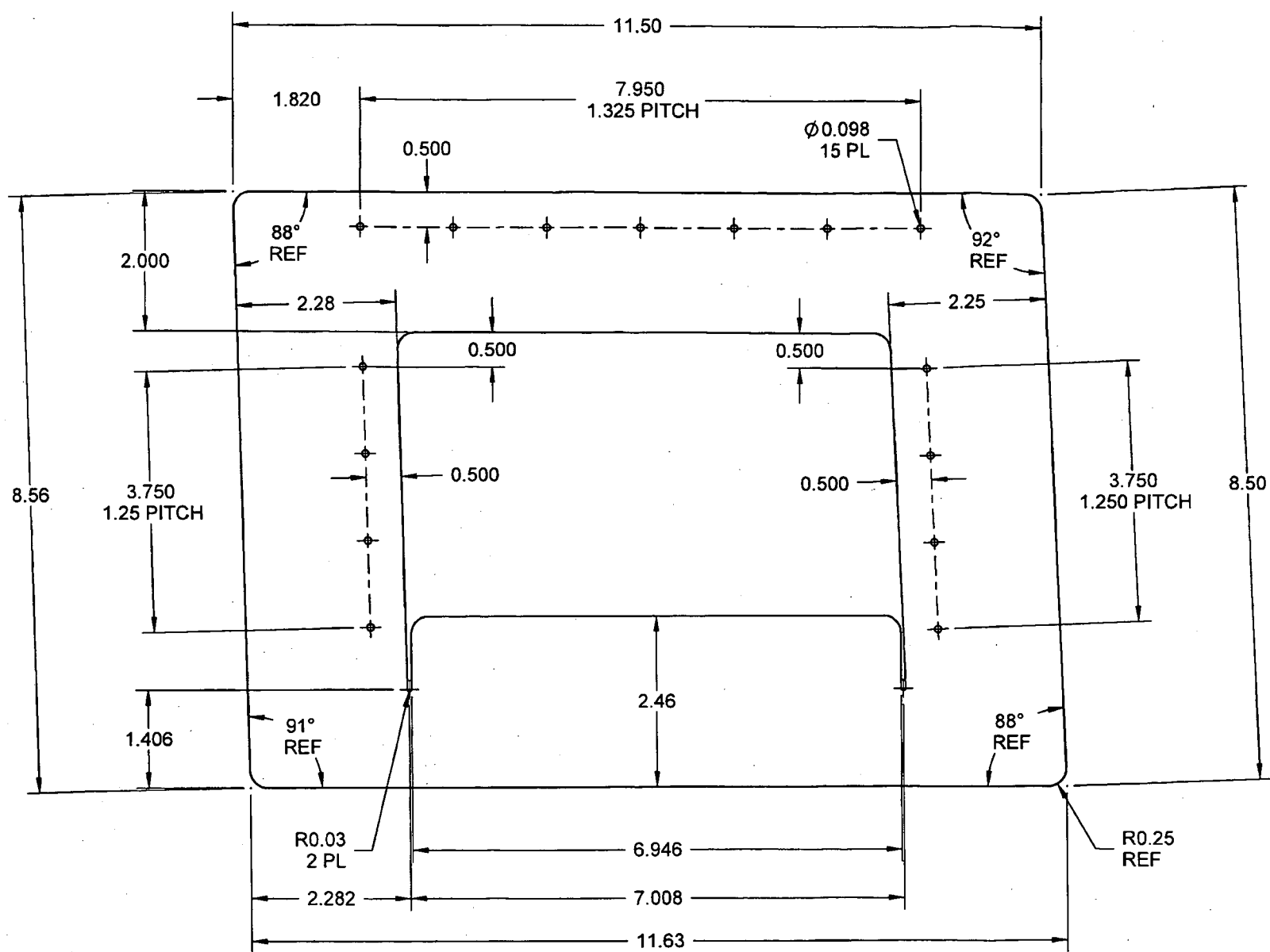


D3608-1F LOWER DOUBLER

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D3608-3F UPPER DOUBLER

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